NISSAN
MOTOR CORPORATION

NPQP v 2.0

NPQP - QA TABLE B

Project: X99X/**		Safety ☐ Nissan Impt A ☐ Impt B ☐ Impt C ☐OBD ☐ Regulation ☐	Doc. Ref. No./Ve Doc Rev. Date: Doc. Origin Date
Supplier Name: **company ** Business Units	Supplier Code: X000		E-mail:
Supplier Plant: Atsugi Plant	Author:		Tel:
Part Name: ** * Case Comb		Remark	
Part No. : 123456AB0A			
Design Note No. : JPN9999			

QFD Table B in machining process of parts A

Occurrence:
C - Continuous
O - Outbreak

Process:
Quality building : B
Outflow prevention : P

Class	Process	Process Name		Ref:			QA Table A	QA Table A	QA Table A	QA Table A	QA Table A	QA Table A		QA Table A	QA Table A	QA Table A	QA Table A
				mp.Symb			H										
				No.			1		1	1	1	1	1	1		2	2	3	3
				Key Characteristics			1 Caulking Strength		2 Caulking Diameter	3 Squash Height	4 Caulking Groove Width	5 Eccentricity	6 Staking contact amount	7. Thickness after caulking		1 Inner diameter	2 Thickness	1 Outer Diameter	2 Groove Depth
				Characteristics Value			47 MPa or More or 73.1 kN or more		54.2 ± 0.3	9.0 ± 0.2	2.6 ± 0.2	0.5 or Less	0.8 or more	0.6 or more		φ 54 0 to + 0.1	t > 2.1	φ 54 -0.01 ~ -0.05	1.25 ± 0.1
Self Process	0	parts loading and inspection														P	P	P	P
	1	component cleaning																	
	2	Component assembly																	
	3	Staking Caulking					B		B	B	B	B	B	B					
	4	Visual inspection and sampling inspectio					P		P	P	P	P	P	P					
	5	Assembled to the main body																	
	6	leak test																	
	7	Boxing and shipping																	
	Process Capability						2.63		6.07	0.78	0.51	6.44				6.08	11.8	2.9	4.32
				SOP															
	Measuring Accuracy						0.1		0.01	0.01	0.01	0.01	0.01	0.01		0.01	0.01	0.001	0.01
	Failure Mode						C		C	C	O	C	O	O		O	O	O	O
Confirmation Table	Ensuring Symbol																		
	No. Receiving	Ensuring Detail					---		---	---	---	---	---	---		dimensional measurement	dimensional measurement	dimensional measurement	dimensional measurement
		Measuring Device (Means, Method)					---		---	---	---	---	---	---		Inner diameter Micro	Outer Diameter Micro	Outer Diameter Micro	vernier caliper
		Confirmation Frequency					---		---	---	---	---	---	---		n=1 /day	n=1 /day	n=1 /day	n=1 /day
	Ensuring Symbol																		
	No. Manufacturing	Ensuring Detail					caulking control *nail wear control *nail load *nail stroke									---	---	---	---
		Measuring Device (Means, Method)					load cell displacement meter				Counter	centering	load cell displacement meter	load cell displacement meter		---	---	---	---
		Confirmation Frequency					100%				conditio n table	X-R control chart	100%	100%		---	---	---	---
	Ensuring Symbol																		
	No. Outflowing	Ensuring Detail					dimensional measurement		dimensional measurement	dimensional measurement	dimensional measurement	dimensional measurement	dimensional measurement	dimensional measurement					
		Measuring Device (Means, Method)					Hydraulic or Amsler		BLADE Micro	height Gauge	vernier caliper	dial gage	Cut/Mic roscope	Cut/Mic roscope					
		Confirmation Frequency					n=1 /day		n=3 /day	n=3 /day	n=3 /day	n=3 /day	n=1 /day	n=1 /day					
Detectability (Overlooking Frequency)																			
Conformity of Detectability																			
Concern																			
Improvement																			

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